

Work Order ID 58777

Tuesday, May 18, 2010 3:09:22 PM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Assembly (350)

Stop



Start Date: 5/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MP

Date: 10-5-18 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4030	B

100 Pick Kit



Packaging

Packaging

0.00

10-5-21 SF

110



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

0.00

ES 10/5/20 ①

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. J. 5/26

0.00

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

Identify as per dwg & Stock Location:

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Packaging

Memo

PPR 58777

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3917-3 		Manufactured				100	Each	24.0000		6	<i>ES-0/05/26</i>	<i>B58892 (ex)</i>
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				ST096			24					
					57144		1					
					58186		23					
D3953-3 		Manufactured	No			100	Each	1.0000		2	<i>B58858</i>	<i>S</i>
Gas Spring Stud, Lid				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				ST101			1					
					57978		1					
D3953-7 		Manufactured	No			100	Each	9.0000		2	<i>10-5-21</i>	<i>S</i>
Spring Spacer				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				ST101			9					
					53970	<i>basket</i>	9					
D3953-9 		Manufactured	No			100	Each	26.0000		2	<i>10-5-21</i>	<i>J</i>
Gas Spring Washer				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				ST101			26					
					53642		26					

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D3953-17		Manufactured	No			100	Each	2.0000	2		10-5-21	SF

Gas Spring Spacer

D3953-19



Gas Spring Bracket

Location

Location	Loc Qty	Loc Code
ST101	2	
57143	2	

Location

Location	Loc Qty	Loc Code
ST101	11	
57607	11	

D3953-21



Gas Spring Bracket

Location

Location	Loc Qty	Loc Code
ENG	6	
56407	6	

Location	Loc Qty	Loc Code
ST102	13	
57145	13	

D3969-3



Spring (Basket Lid)

Location	Loc Qty	Loc Code
100	Each	0.0000

B56386

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-14A Bolt		Purchased	No			100	Each	86.0000	4		10-5-21	

Location

ST351 86
114330 86

AN3-16A Bolt	Purchased	No	Location	Loc Qty	Loc Code	2	10-5-21	
			ST351	86				

Location

ST352 69
113845 49
114523 20

AN5-17A Bolt	Purchased	No	Location	Loc Qty	Loc Code	4	10-5-21	
			ST352	69				

Location

ST323 54
114324 54
ST339 105
113538 5
114330 100

AN4-12 Bolt	Purchased	No	Location	Loc Qty	Loc Code	3	10-5-21	
			ST323	54				

Location

ST357 44
114292 44

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN310-4 		Purchased	No			100	Each	55.0000	3		10-5-21	SJ

NUT

Location

Location	Loc Qty	Loc Code
ST139	30	
114341	30	
ST314	5	
113845	5	
ST349	20	
114341	20	

AN310C4



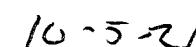
Nut

Purchased

No

Location	Loc Qty	Loc Code
100	76.0000	

2



10-5-21

SJ

MS21042L3



Nut

Purchased

No

Location	Loc Qty	Loc Code
100	1,426.000	

6



10-5-21

SJ

Location	Loc Qty	Loc Code
ST300	1426	
113537	20	
113644	406	
114523	1000	

6

W/O:		WORK ORDER CHANGES					
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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			100	Each	565.0000	4		16-5-21	SL

Nut

Location	Loc Qty	Loc Code
ST300	565	
113523	26	✓
113537	3	
114108	36	
114437	100	
114449	400	

MS24665-151



Purchased

No

.....

100

Each

686.0000

3



16-5-21

SL

Cotter Pin

Location	Loc Qty	Loc Code
ST309	686	
17566	686	

MS24665-300



Purchased

No

.....

100

Each

86.0000

2



16-5-21

SL

Cotter Pin

Location	Loc Qty	Loc Code
ST309	86	
105279	2	
110123	84	

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
NAS1149F0432P 						100	Each	347.0000	6		10-5-21	

Washer

Location	Loc Qty	Loc Code
ST275	347	
112940	92	
114405	1	
114576	254	

NAS1149F0563P

Purchased

No

Location	Loc Qty	Loc Code
ST275	100	

Each

260.0000

4



10-5-21

Washer

Location	Loc Qty	Loc Code
ST275	60	
108471	60	

ST298

100

Each

200

200



10-5-21

NAS1149F0332P

Purchased

No

Location	Loc Qty	Loc Code
ST275	887	

18057

100

Each

887

887



10-5-21

WASHER

Location	Loc Qty	Loc Code
ST297	182	
114292	182	

114292

100

Each

182

182



10-5-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

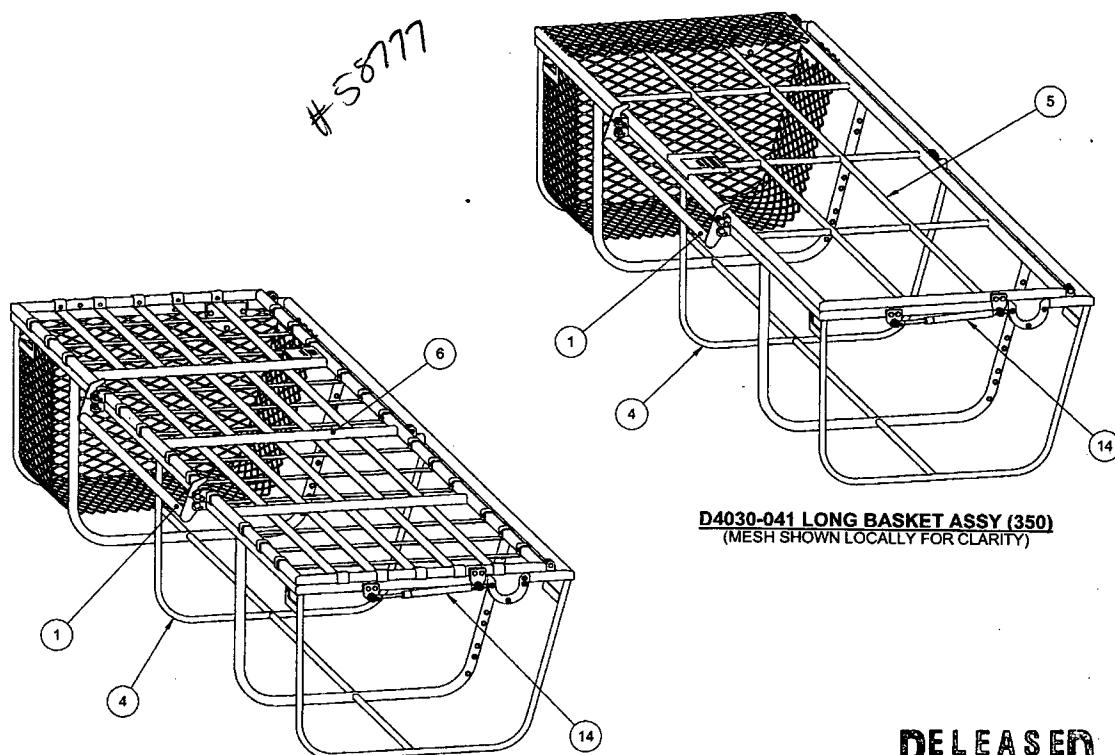
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
X			D4030-041	LONG BASKET ASSY (350)
X			D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6	1		D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17	2		AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20	2		AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8		NAS1149F0332P	WASHER
31	2		NAS1149C0432R	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-04-14
NP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)		JPH	10.04.06
A	NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH	DRAWING NO. D4030		
CHECKED		REV. B SHEET 1 OF 3		
MFG. APPR.		APPROVED BY		
APPROVED		TITLE LONG BASKET ASSY (350) NTS		
DE APPR.		SCALE		
DATE	10.04.06			

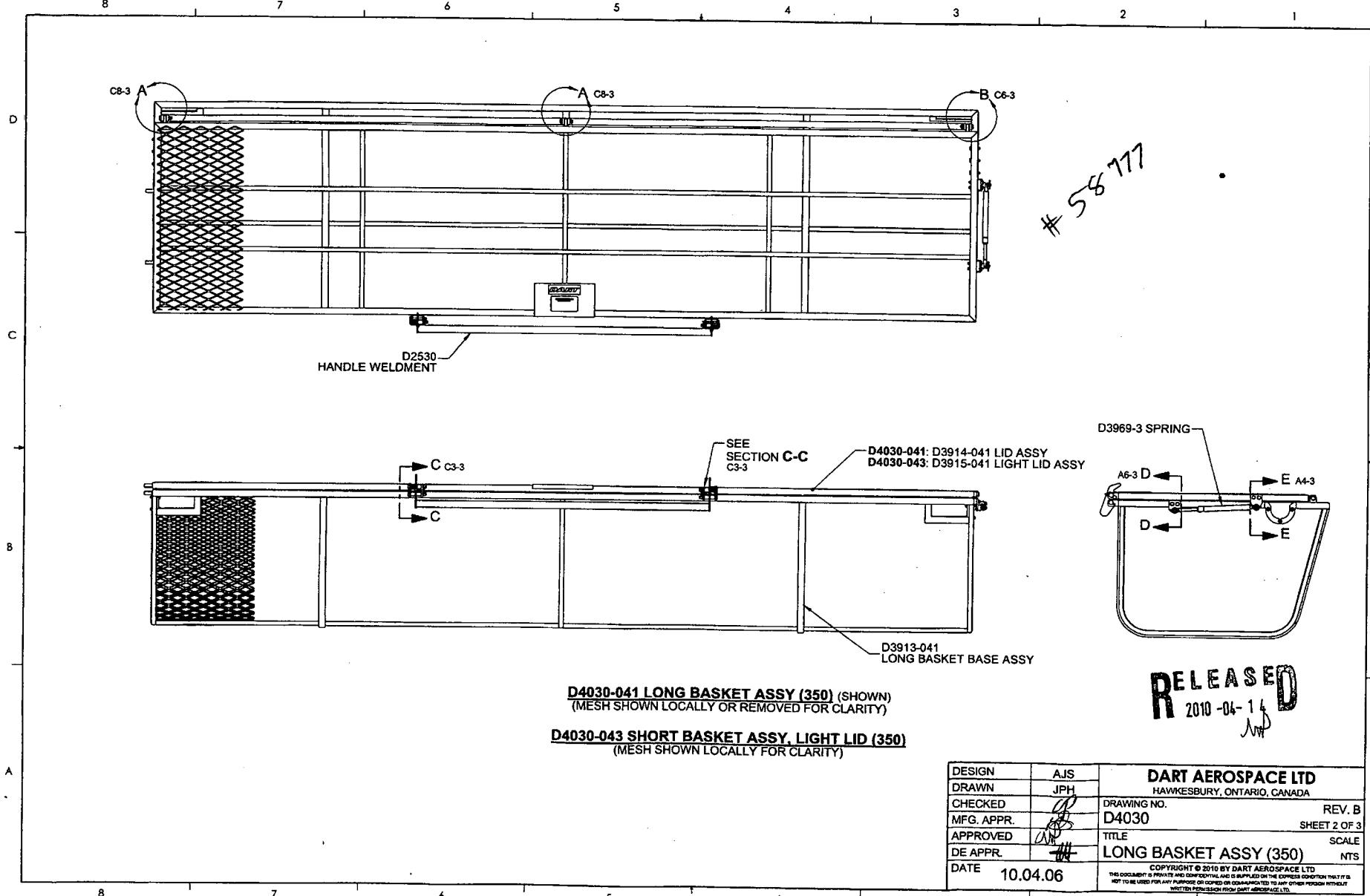
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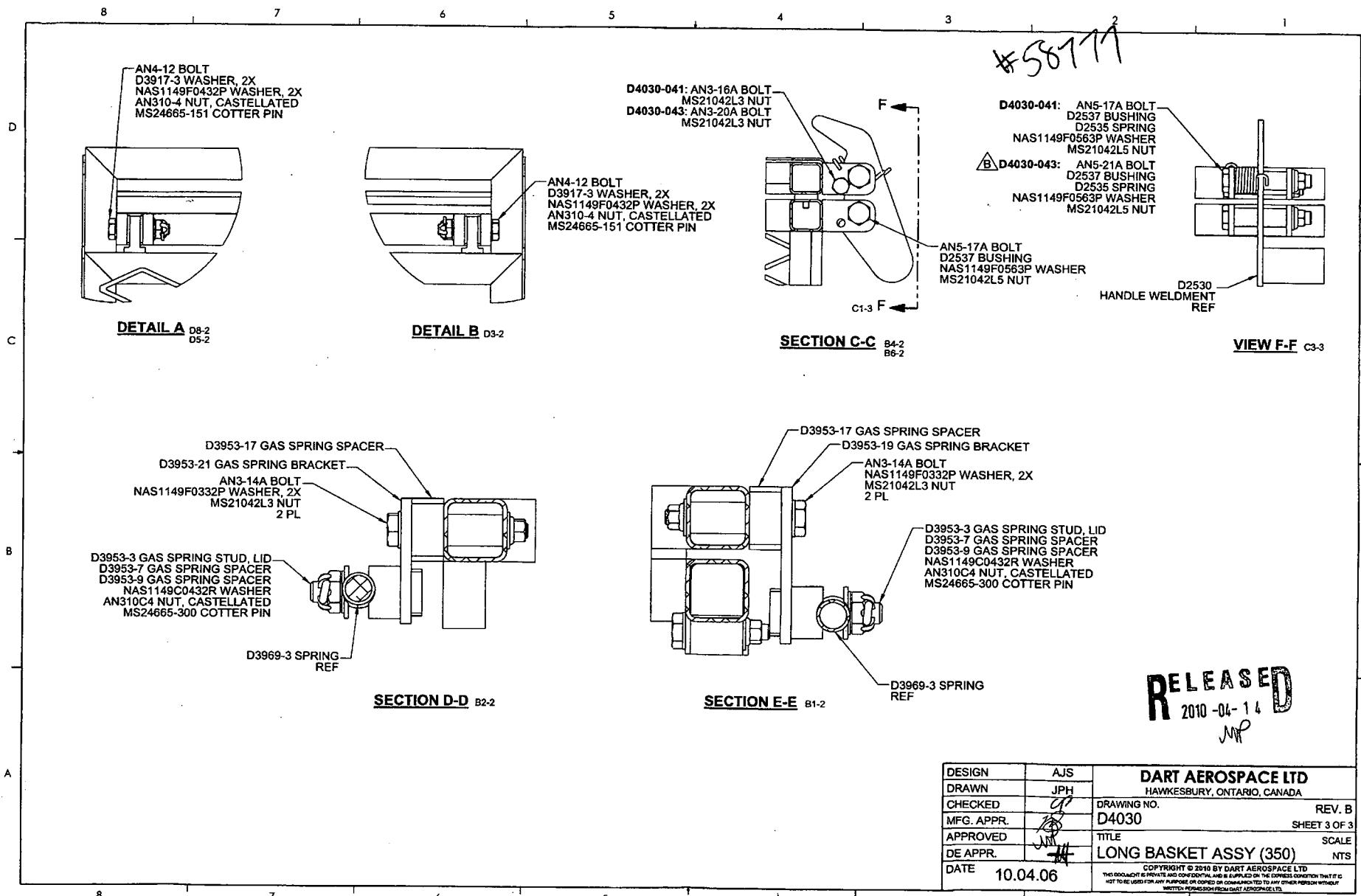
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